

# Work Order ID 75899

November-01-11 2:23:14 PM

**\*75899\***

Page 1

Item ID: D412-709-015

Revision ID:

Item Name: Hinge Panel Door Modification

Start Date: 01/11/2011 Start Qty: 1.00

Required Date: 15/11/2011 Req'd Qty: 1.00

Reference:

*Costed  
see w/o*

Accept

*77263  
ATTACHED*

**\*N900040100\***

Setup Start

**\*NS1\***

Stop

**\*NS2\***

Cust Item ID:

Customer:

Run Start

**\*NR1\***

Stop

**\*NR2\***

Approvals: Process Plan: *M.L.J*

Date: *11/11/01*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

N/A

Rev A

100

0.00

**\*100\***

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D412-709 bluefile & type labels per PPP D412-709-015 CHG802

*W 11-11-29 (1)  
JG dcr M.L.J 11-11-29 (1)*

105

0.00

Pick Kit

**\*105\***

Packaging

Memo

0.00

Packaging

*SP 11-11-29.*

110

0.00

QC4- 100% Inspect kits for completeness

**\*110\***

QC

Memo

0.00

Quality Control

*W 11-11-29 (1)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 75899

**\*75899\***

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November-01-11 2:23:14 PM

Item ID: D412-709-015

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Hinge Panel Door Modification

Stop **\*NS2\***

Start Date: 01/11/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 15/11/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
<b>*120*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-709-015								
	Location: <u>B-59</u>								
	PPP Rev: _____								
130	QC21- Final Inspection - Work Order Release	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

*SP 11-11-30*

*ME 11-11-30*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 75899

**\*75899\***

Parent Item: D412-709-015

**\*D412-709-015\***

Parent Item Name: Hinge Panel Door Modification

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev. B 05.03.08 D3240-1 no longer made in house

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2126		Manufactured	No			110	f	197.0058	6	6.315789			
*D2126*													
Seal									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST405				197.00579					
				57106				4					
				68336				193.00579					
Cut each seal 72.00" long													
D3236-1		Manufactured	No			110	Each	3.0000	1	1			
*D3236-1*													
Window									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST217				3					
				72947				3					
D3240-1		Manufactured	No			110	Each	6.0000	1	1			
*D3240-1*													
Frame									**				
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST217				6					
				65871				2					
				73223				4					

Cut each seal 72.00" long

D3236-1

Window

D3240-1

**\*D3240-1\***

Frame

SP 11-11-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## 5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-709-011	ESCAPE PANEL MODIFICATION KIT
1	X						D412-709-013	ESCAPE PANEL PUSH OUT WINDOW KIT
		X					D412-709-015	HINGE PANEL DOOR MODIFICATION KIT
		1	X				D412-709-017	HINGE PANEL DOOR REPLACEMENT WINDOW KIT
				X			D412-709-019	CARGO DOOR PUSH OUT WINDOW KIT
					X		D412-709-021	HINGE PANEL DOOR PUSH OUT WINDOW MODIFICATION KIT
					1	X	D412-709-023	HINGE PANEL DOOR REPLACEMENT PUSH OUT WINDOW KIT
			1				D2126-0720	LOCKING SEAL
1							D3118-3	SIGN ASSEMBLY
				1			D3136-041	WINDOW ASSEMBLY
	1						D3136-043	WINDOW ASSEMBLY
1							D3224-1	FRAME
			1				D3236-1	WINDOW
						1	D3237-1-0720	SEAL RETAINER
	1			1			D3237-1-0980	SEAL RETAINER
						1	D3237-3-0720	SEAL FILLER
	1			1			D3237-3-0980	SEAL FILLER
2							D3239-1	COVER
		1					D3240-1	FRAME
						1	D3543-1	HINGE PANEL DOOR PUSH OUT WINDOW
					1		D3543-3	HINGE PANEL DOOR PUSH OUT WINDOW FRAME
	1			1		1	D3561-1	WINDOW SEAL TOOL
3							AN6-20A	BOLT
2							AN960JD10L	WASHER
5							AN960JD616	WASHER
5							AN960JD616L	WASHER
2							MS21042L3	NUT
3							MS21042L6	NUT
2							MS35207-262	SCREW

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Revision: C

Date: 06.11.27

# Work Order ID 77263

**\*77263\***

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Wednesday, November 30, 2011 2:49:35 PM

Item ID: D412-709-015 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Hinge Panel Door Modification  
 Start Date: 11/30/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 12/1/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: mf Date: 11-11-30 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
N/A	Rev A								
100	DOCUMENT CONTROL	0.00							
<b>*100*</b>									
DC	Memo	0.00							
Document Control	Photocopy D412-709 bluefile & type labels per PPP D412-709-015 CHG002								
105	Pick Kit	0.00							
<b>*105*</b>									
Packaging	Memo	0.00							
Packaging									
110	QC4- 100% Inspect kits for completeness	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

See  
w/o  
#75899.



**Work Order ID 77263****\*77263\***

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Wednesday, November 30, 2011 2:49:36 PM

Item ID: D412-709-015

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Hinge Panel Door Modification

Start Date: 11/30/2011 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 12/1/2011 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Packaging	0.00							
<b>*120*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-709-015								
	Location: _____								
	PPP Rev: _____								
130	QC21- Final Inspection - Work Order Release	0.00							
<b>*130*</b>									
QC	Memo	0.00							
Quality Control									

MF  
11-11-30

# Picklist Print

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Work Order ID: 77263

Parent Item: D412-709-015

Parent Item Name: Hinge Panel Door Modification

Start Date: 11/30/2011

Required Date: 12/1/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev. B 05.03.08 D3240-1 no longer made in house

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2126 Seal Cut each seal 72.00" long		Manufactured	No			110	f	651.6858	6	6.3157895			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST405		651.68579							
				57106		4							
				68336		147.68579							
				76094		500							
D3236-1 Window		Manufactured	No			110	Each	2.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST217		2							
				72947		2							
D3240-1 Frame		Manufactured	No			110	Each	5.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST217		5							
				65871		1							
				73223		4							

See  
w/o  
75899